

Work Order ID 66705

Thursday, February 24, 2011 10:32:38 AM

Page 1

Item ID: D4281-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 2/25/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-02-24

Tooling:

Date:




QC: Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4281	A								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

ASAP

B11-2-24

6

B11-2-24

x6

Sulob25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Manufacture as per dwg

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

1- Face to size as per dwg
2- deburr

JFS. 11/02/25

6 0

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

JFS 11.02.25

6 0

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 0 All blocks

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

POWDER COAT

Start Time: 7:55

Oven Temperature: 320°

Finish Time: 8:25

0.00

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

180

Identify as per dwg & Stock Location: 139

0.00



Packaging

Packaging

Memo

0.00

6 11-2-28

(6)

7m 11/2/28

6/2/28 (6)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/28 J
ME
11-02-28

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Picklist Print

Thursday, February 24, 2011 10:32:35 AM

Page 1

Work Order ID: 66705

Parent Item: D4281-1

Parent Item Name: Spacer



Start Date: 2/25/2011

Required Date: 3/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
10.12.02 AS PER DWG REV.A DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X02600		Purchased		No		100	f	0.0000	0.26333	1.108758	1.6		



FB 11-2-24

6061T6Bar .750X 3"

1703T
14252

(6)

11.02.24 perm. chg.

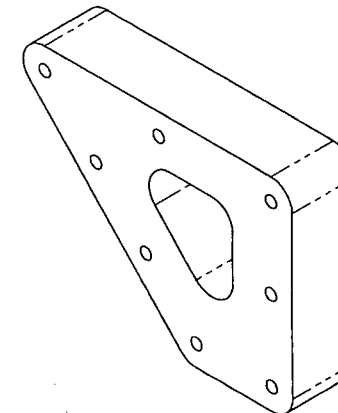
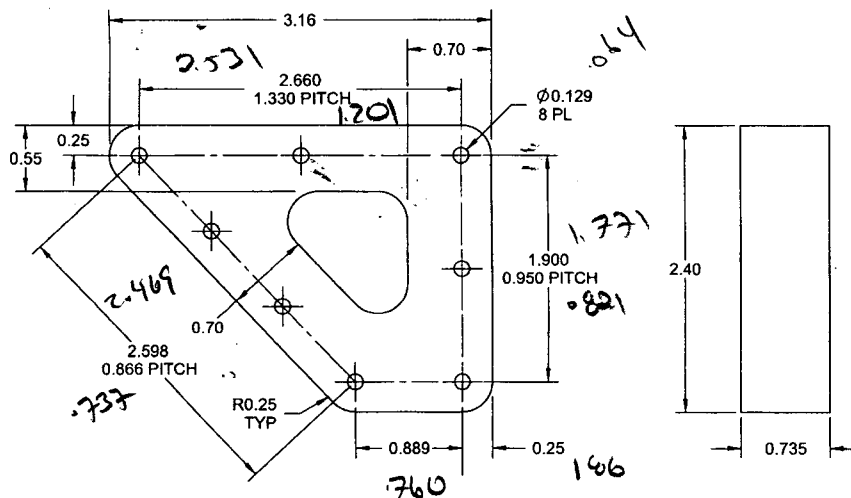
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D4281-1 SPACER

D4281-1 SPACER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

RELEASED
2010-11-30

A		NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4281 TITLE SPACER COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT EXPLICIT PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	JPH			
CHECKED	JPH			
MFG. APPR.	JPH			
APPROVED	JPH			
DE APPR.	JPH			
DATE	10.11.25		REV. A	SHEET 1 OF 1
		SCALE		NTS

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